DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029389
Date Inspected: 01-Apr-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	As noted below.			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: Tower

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA was present to perform Ultrasonic Testing (UT) inspection verification on Electroslag (ESW) welds inside of the Tower. The purpose of the UT inspection was for the detection of planar indications utilizing both the 'pulse echo' (PE) technique and the 'pitch and catch' (PC) technique for further discontinuity evaluation on ESW welds where previous discontinuities were detected by the single pulse echo search unit.

The data collected from utilizing the P/C technique is for information only and the UT inspection was performed as a joint inspection with ABF/JV Quality Control (QC) Smith Emery NDT personnel. The summary of the joint ultrasonic inspection performed on this date was as follows:

ABF Standard Reference Block: 1mm Hole –

Initial calibration off of IIW Block with one (2) transducer cables plugged in the machine.
Transducer: Benchmark; 2.25 MHz
1mm Hole: PE Decibel rating (+2) / PC Decibel rating (0).

Initial calibration off of IIW Block with one (1) transducer cable plugged in the machine.
Transducer: Benchmark; 2.25 MHz
1mm Hole: PE Decibel rating (+10) / PC Decibel rating (+10).

ABF Standard Reference Block: Middle Third Notch –

Initial calibration off of IIW Block with one (2) transducer cables plugged in the machine.
Transducer: Benchmark; 2.25 MHz
Middle Third Notch: PE Decibel rating (+11) / PC Decibel rating (-17).

Initial calibration off of IIW Block with one (1) transducer cable plugged in the machine.
Transducer: Benchmark; 2.25 MHz
Middle Third Notch: PE Decibel rating (+15) / PC Decibel rating (-14).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer